

**Work Order ID 104255**

July-09-13 11:43:14 AM

**\*104255\***

Page 1

Item ID: D3183-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 7/09/13 Start Qty: 4.00

**\*4\***

Required Date: 7/09/13 Req'd Qty: 4.00

**\*4\***

Reference:

Approvals: Process Plan: MLJDate: 13-07-12

Tooling:

Date: \_\_\_\_\_

Run

Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

**\*100\***

Bandsaw

BAND SAW

Jeaspa Bandsaw

Memo

Cut blanks: (1.500" x 2.250") 5.500" long

DAS  
140  
9-89

13/08/06

8 Ø

PTO  
Proc #3 →

110

**\*110\***

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3183-3 as per Folio FA322 and Dwg D3183 Identify as D3183-  
32-Deburr3-Scribe batch number

13-08-07

Ø

SLB-8-9

120

**\*120\***

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

13-08-07

SLB-8-9

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

### Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>			Engineering <input type="checkbox"/>		
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>			Quality <input type="checkbox"/>		
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>			Other <input type="checkbox"/>		
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

**Work Order ID** 104255

July-09-13 11:43:14 AM

\*104255\*

Page 2

**Item ID:** D3183-043

Accept

\*N900040100\*

Setup

Start

\*NS1\*

**Revision ID:**

**Item Name:** Bracket Assembly

Stop

\*NS2\*

**Start Date:** 7/09/13    **Start Qty:** 4.00

\*4\*

**Required Date:** 7/09/13    **Req'd Qty:** 4.00

\*4\*

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run

Start

\*NR1\*

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop

\*NR2\*

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

130

QC8- Inspect parts - second check

0.00

OAS

40

9-89

8

Ø

13/08/12

140

Small Fab

0.00

8X

J.3/08/15

\*140\*

Memo

0.00

Small Fab

Assemble D3183-043 as per Dwg D3183.

150

QC5- Inspect part completeness to step on W/O

0.00

OAS

27

08

8

\*150\*

Memo

0.00

QC

Quality Control

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General				
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>	
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>	
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Other <input type="checkbox"/>	
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>		
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>			
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>			
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>			
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>			

**Work Order ID** 104255

July-09-13 11:43:14 AM

\*104255\*

Page 3

**Item ID:** D3183-043

Accept

\*N900040100\*

Setup

Start

\*NS1\*

**Revision ID:**

**Item Name:** Bracket Assembly

Stop

\*NS2\*

**Start Date:** 7/09/13    **Start Qty:** 4.00

\*4\*

**Required Date:** 7/09/13    **Req'd Qty:** 4.00

\*4\*

Cust Item ID:

Customer:

**Reference:**

**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

**Sequence ID/  
Work Center ID**

**Operation  
Description**

160

Identify as pcr dwg & Stock Location: *ST235B*

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

**\*160\***

Packaging

Packaging

Memo

0.00

*8x M. D. 13-08-16*

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Quality Control

Memo

0.00

*MLS 13-08-16*

*CD 13/08/16*

DQA:

*Shut*

Date: 13/08/22

QA Closed:

*XH*

Date: 13/08/22



## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only 

Work Order: <u>104255</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3183-043</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>B-2969</u>	Scrap <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input checked="" type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	13.08.12				A.P. 13.08.12	NONVIGILANT DEVIATION, NO EFFECT ON STRENGTH OF PART. ACCEPTABLE	A.P. 13.08.12	DAS 40 9-89	DAS 16 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	X								
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General									
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced						
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input checked="" type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up						
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure						
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld						
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled						
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge							
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread								
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration								
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence								

## Picklist Print

July-09-13 11:43:13 AM

Page 1

**Work Order ID:** 104255

Parent item: D3183-043

**Parent Item Name:** Bracket Assembly

Start Date: 7/09/13

**Required Date:** 7/09/13

**Start Qty: 4.00**

**Required Qty: 4.00**

**Comments:** IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rcv:B Changed Mat Size 08-06-26 JLM Verified By:EC

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order:			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General									
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced						
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up						
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure						
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld						
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled						
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge							
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread								
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration								
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence								

DART AEROSPACE LTD	Work Order:	104255
Description: Bracket	Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	-190	/			
R0.063	+/-0.010	.063	/			
0.182	+/-0.010	-183	/		Vern	SL-10
0.070	+/-0.010	-070	/			
0.100	+/-0.010	-101	/			
Ø0.201 x 0.100	+/-0.010	-196 X 099	/			
0.182	+/-0.010	-181	/			
5.32	+/-0.030	5.322	/			
5.036	+/-0.010	5.038	/		H-G	
2.120	+/-0.010	2.120	/			
1.290	+/-0.010	1.290	/		Vern	SL-10
0.365	+/-0.010	-365	/			
0.218	+/-0.010	-214	/			
1.030	+/-0.010	1.030	/			
1.90	+/-0.030	1.890	/			
1.012	+/-0.010	1.010	/			
Ø0.201 x 0.100	+/-0.010	200X.099	/			
0.786	+/-0.010	-785	/			
Ø0.392	+0.002/-0.000	-393	/		mic	SL-4
R0.19	+/-0.030	-190	/			
3.954	+/-0.010	3.953	/		H-G	
0.162	+/-0.010	-161	/		Vern	SL-10
R0.19	+/-0.030	-19	/			
R0.25	+/-0.030	-250	/			
4.26	+/-0.030	4.261	/			
2.080	+/-0.030	2.100	/			
1.155	+/-0.010	1.160	/			
0.162	+/-0.010	-162	/			
0.36	+/-0.030	-370	/			
0.615	+/-0.010	-620	/			
0.435	+/-0.010	-432	/			
0.200	+/-0.010	-200	/			
0.381	+/-0.010	-390	/			
0.032	+/-0.010	028	/		D-G	SL-7

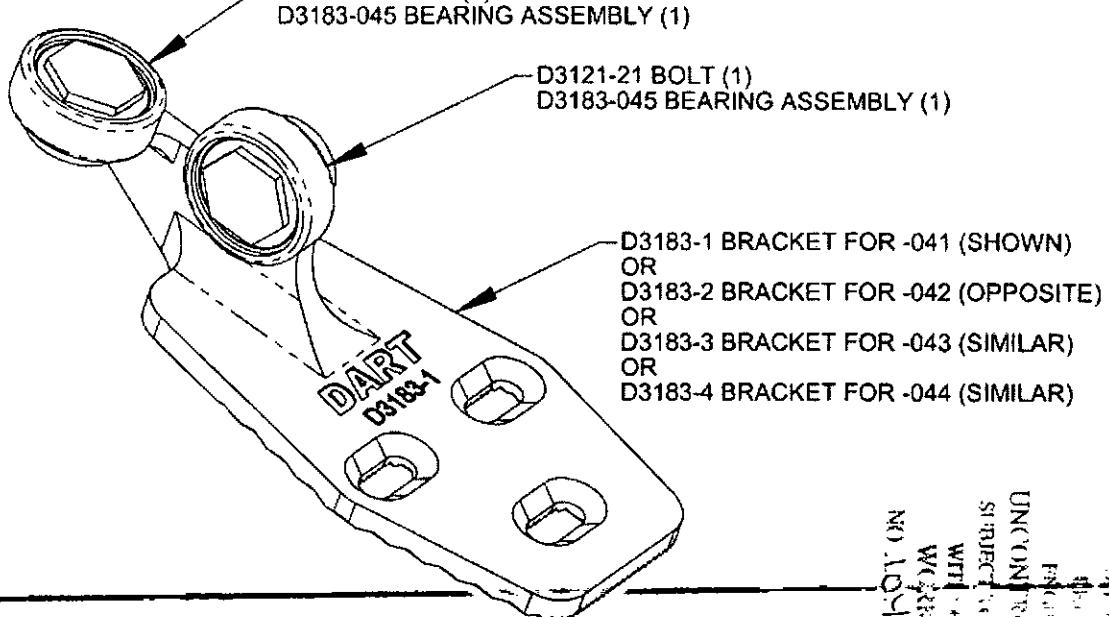
Measured by:	SL	Audited by:	40 9-89	Prototype Approval:	N/A
Date:	13-8-12	Date:	13/08/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD	DA

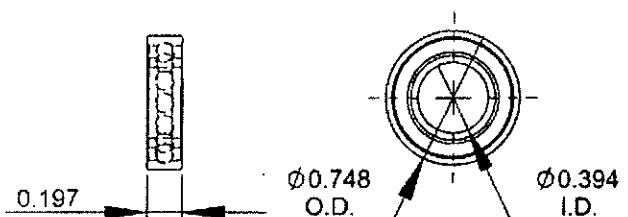


**DART**

DESIGN <i>#</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

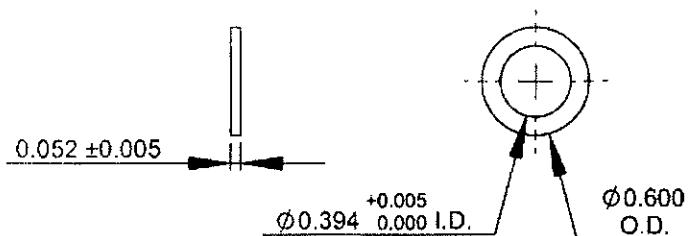
**RELEASED**  
04.03.01 G**DEO ATTACHED**

**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**



#### **D3183-5 BEARING SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE,  
CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



#### **D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R)  
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



*10425*

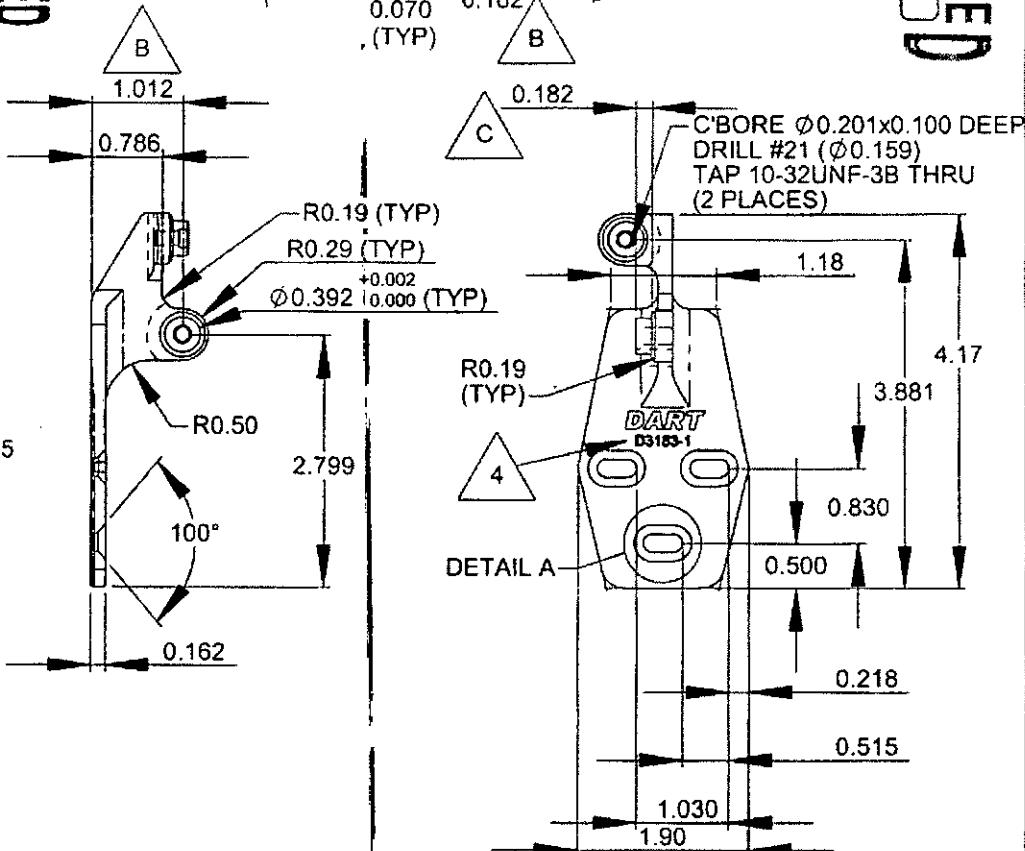
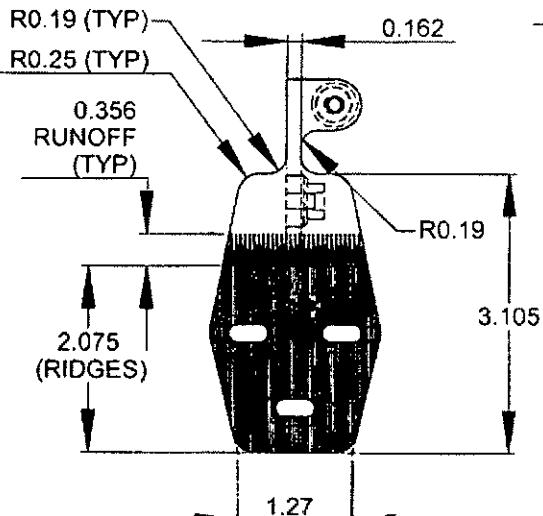
**DART**

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© DART AEROSPACE LTD.

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	404.02.17	DRAWING NO. <b>D3183</b>
TITLE	BRACKET ASSEMBLY	REV. C
SHEET 2 OF 4		SCALE 1:2

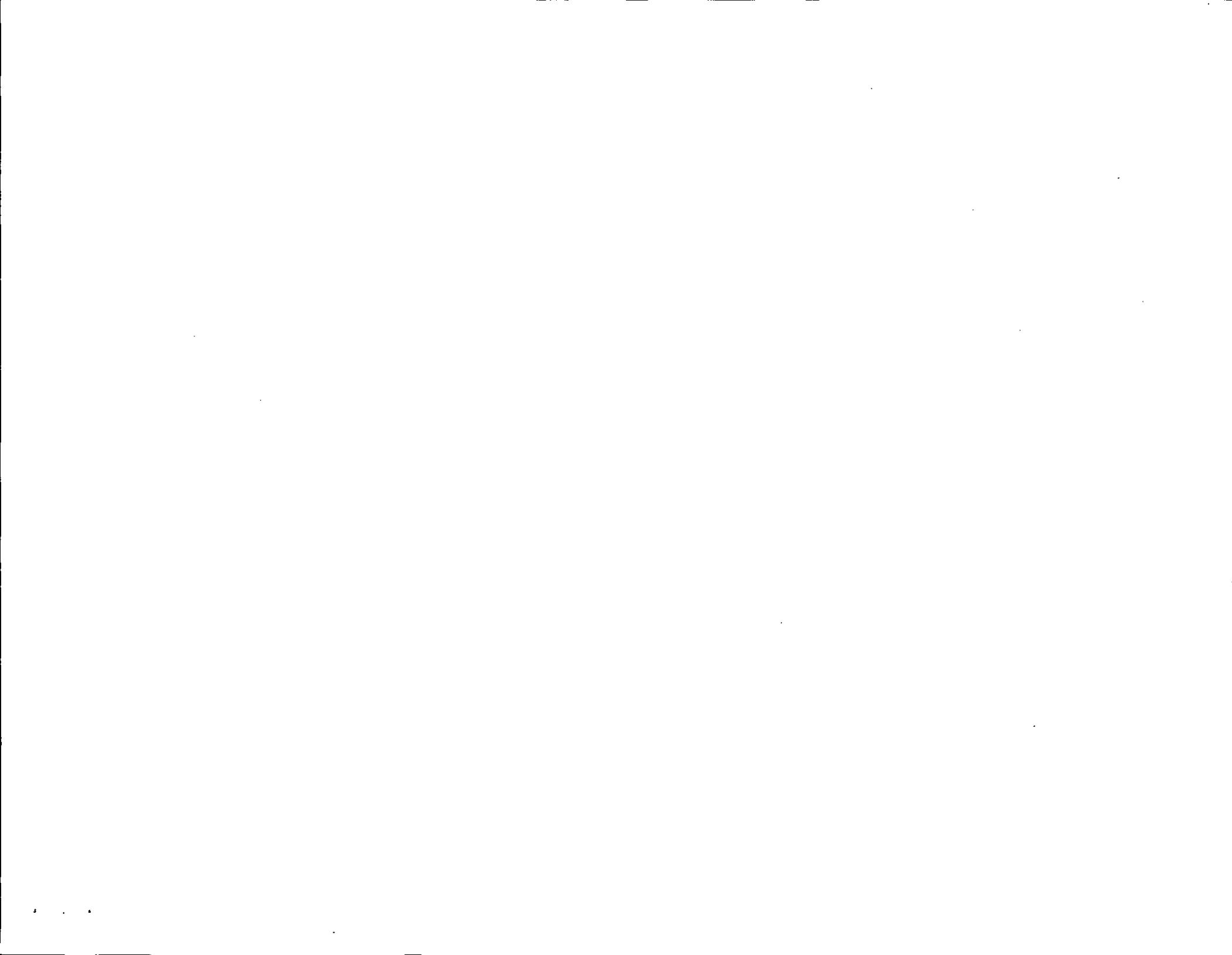
**RELEASED**

**DETACHED**



**D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

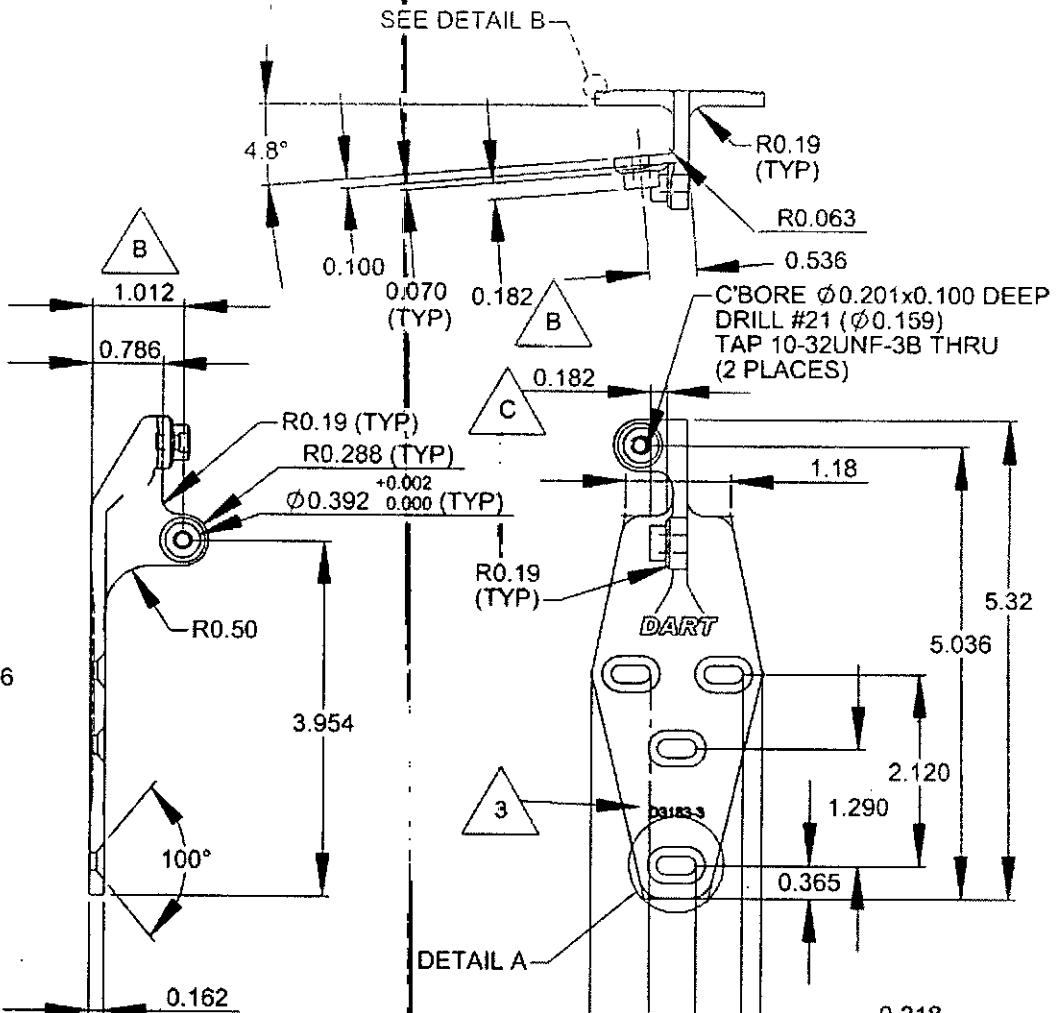
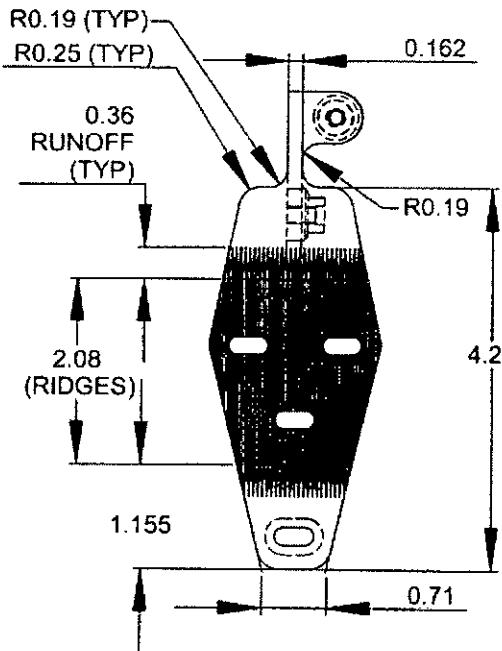




OAC COPY  
0303

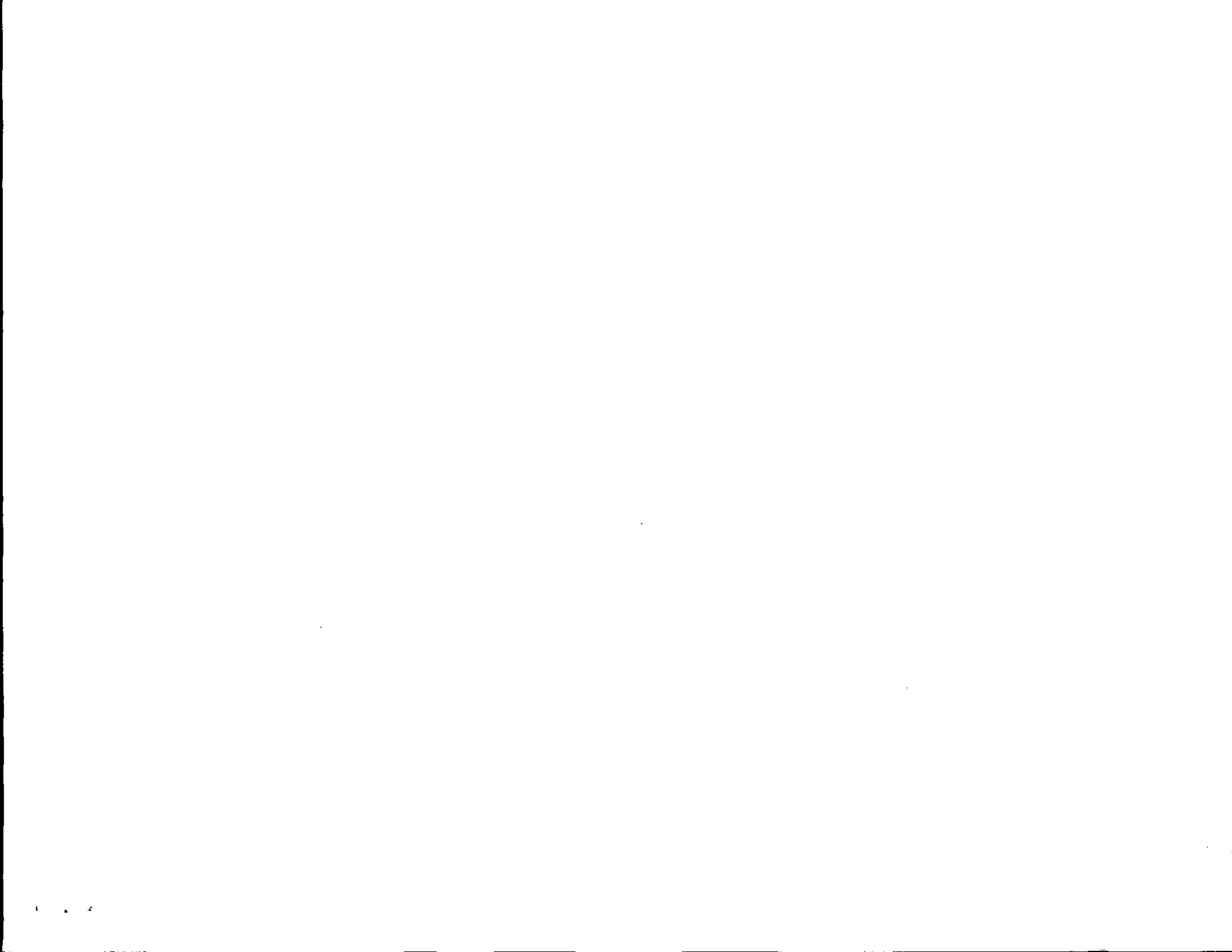
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO.
		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 3 OF 4
		SCALE
		1:2

DEO ATTACHED



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

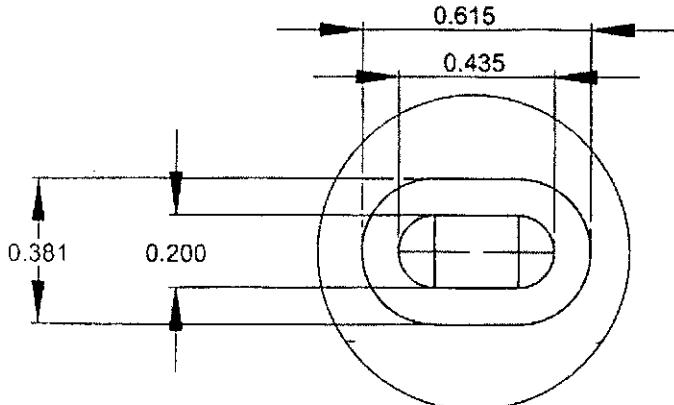
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES





CL  
CO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	

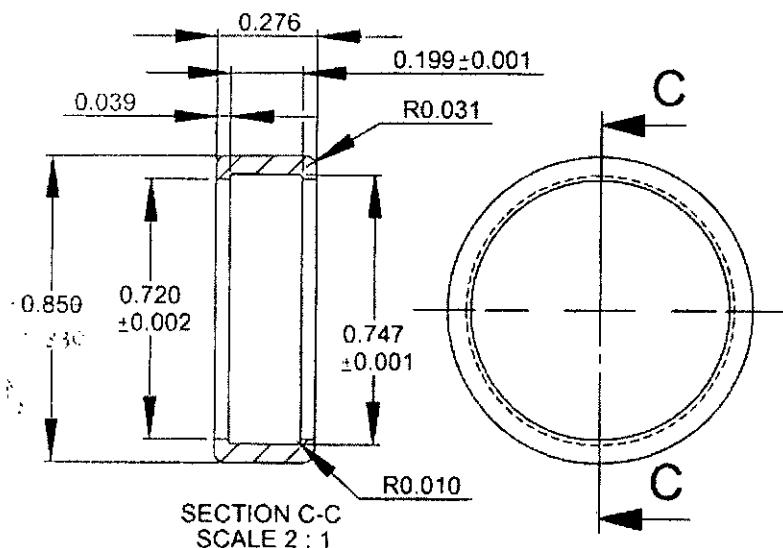
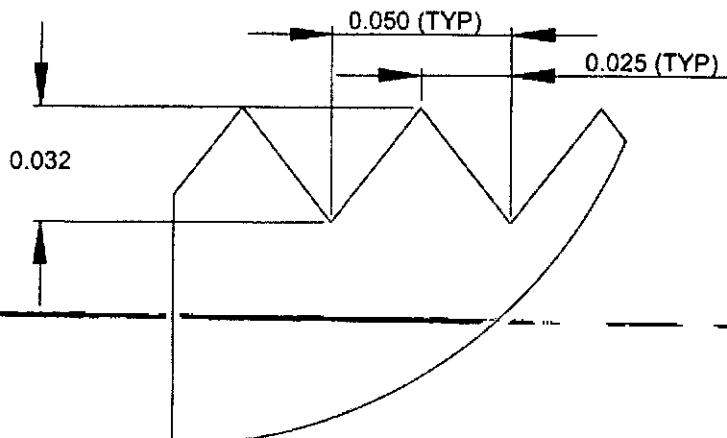


DETAIL A (2 : 1)

RELEASED  
04-03-01 AF

DEO ATTACHED

DETAIL B (20 : 1)



SECTION C-C  
SCALE 2 : 1

#### D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

#### D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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10/25/01



104255

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER	O.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>QP</i>	CHECKED <i>AA</i>	MFG. APPR. <i>AA</i>	APPROVED <i>NP</i>	DE APPR. <i>AA</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30	DATE 10/06/30	

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]  
 Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

**RELEASED**  
 2010-07-22  
*NP*

